

Fabricator 211i

MULTI PROCESS WELDING SYSTEM



Fabricator® 211i
Part No. W1004201

Comes Complete with:

- * Fabricator 211i Power Supply
- * 12 ft Tweco® WeldSkill® 220 Amp MIG Gun
- * Contact Tips (1 each):
 - .023" (0.6 mm)
 - .030" (0.8 mm)
 - .035" (0.9 mm) Installed
 - .045" (1.2 mm)
- * Victor Argon Regulator/Gauge & 10 ft (3 m) Hose
- * Tweco WeldSkill 200 Amp electrode holder with 13 ft (4 m) lead
- * Tweco WeldSkill 200 Amp ground clamp with 10 ft (3 m) lead
- * Drive Rolls:
 - .023" / .030" (0.6 / 0.8 mm) V Groove
 - .023" / .035" (0.6 / 0.9 mm) V Groove (Installed)
 - .030" / .035" (0.8 / 0.9 mm) for flux cored wire
- * 4 general purpose stick electrodes (E6013)
- * Operator's Manual & CD
- * 9 ft (2.75 m) Power Cord and NEMA 6-50P 230V AC Plug

QUICK SPECIFICATIONS

PROCESSES

MIG (GMAW)
Flux Cored (FCAW)
Lift TIG (GTAW)
STICK (SMAW)

APPLICATIONS

Automotive Repair & Customization
Farms & Ranches
Training Institutions
Maintenance & Repair
Sheet Metal & Light Fabrication
On-site & Portable Welding Applications
Home Hobbyists (DIY)

RATED OUTPUT

210A / 24.5V @ 20% Duty Cycle (230V)
140A / 21V @ 20% Duty Cycle (115V)

MAX. OPEN CIRCUIT VOLTAGE

62V DC

AMPERAGE RANGE

115VAC: 5 – 150 Amp, 230VAC: 5 – 210 Amp

WIRE FEED SPEED

67 – 650 IPM (1.7 – 17.8 m/min)

WEIGHT

57.3 lbs (26.5 kg)

ORDER INFORMATION

Part No: W1004201

Description: Fabricator 211i Package

Part No: W1004202

Description: Fabricator 211i Package w/Car

Three Process Capability:

MIG (GMAW/FCAW), **STICK** (SMAW), **TIG** (GTAW).

MIG:

- * **Infinite Voltage Control** with optimized starting performance.
- * **Inductance Control** for arc stability and spatter control.
- * **Tweco MIG Gun** w/12 ft cable and industry standard #4 connection.
- * **Durable Metal Feed Plate** features 2 roll drive system, quick change reversible drive rolls and easy-to-set single scaled wire tension knob.
- * **4", 8" & 12" Spool Capacity** allows easy installation of wire spool sizes.
- * **Spool Gun** ready.
- * **Adjustable Burnback Control.**

STICK:

- * **Adjustable Arc Force Control** for optimum STICK electrode performance.
- * Built in **Hot Start** for easy arc starting.

TIG:

- * **Lift TIG Start:** Provides TIG arc starting without use of high frequency.
- * **Downslope:** Eliminates the crater that can form at the completion of a weld.

Other Features:

- * **Digital Meters:** Voltage and Amperage; Preview and Hold capability.
- * **Excellent Portability:** Lightweight, less than 58 lbs.
- * **Comprehensive Setup Chart:** Weld set up guide for optimum welding performance over a wide range of materials and shielding gases.
- * **Trigger Control:** 4T (Latch) eliminates operator fatigue.
- * **Remote Receptacle:** Enables connection of remote control devices and Spool Gun.
- * **Quick Change Polarity:** Simple quick change polarity (no tools required) from the front of the power source.
- * **Overload Protection:** Shuts down the power source to protect the internal electrical components from overheating.
- * **IP23S:** Suitable for outdoor use.
- * **Intelligent Fan Control:** Operates when welding commences to cool components & reduce airborne contaminants pulled through the power source.
- * **Multi-Voltage Input Power:** 115 & 208/230 VAC.



CONTROL PANEL

Digital Meters WFS /
Amps and Volt Meters

WFS / Amps Control
Knob

Voltage / Arc Force
Control / Down Slope
Control Knob



Process Button Select
MIG, STICK or Lift TIG

Trigger 2T (ON/OFF)
or 4T (Trigger Hold)
selection

Inductance Control
Knob

SYSTEM FEATURES

Local/Remote Switch

Burnback Control

Easy installation
Wire Spool Adaptor &
Braking System

Metal 2 Roll wire drive
system with quick change
drive rolls and single
tension arm

Comprehensive Welding
Setup Chart for welding
process parameters



Control Panel
(Refer Above)

MIG Gun/Spool
Gun Switch

MIG Gun Connection,
Tweco #4

8 pin Remote
Receptacle for
remote devices &
Spool Gun

Heavy Duty
Welding output
terminals with
polarity reversal
capability

SPECIFICATIONS

WELDING DC	
Maximum Output	210 Amp
MIG (GMAW/FCAW) Welding Output @104°F (40°C)	115VAC - 140A / 21V @ 20% Duty Cycle 230VAC - 210A / 24.5V @ 20% Duty cycle
STICK (SMAW) Welding Output @104°F (40°C)	115VAC - 120A / 25V @ 25% Duty Cycle 230VAC - 200A / 25V @ 25% Duty cycle
TIG (GMAW) Welding Output @104°F (40°C)	115VAC - 150A / 16V @ 35% Duty Cycle 230VAC - 200A / 18V @ 25% Duty cycle
Current Range	115VAC: 5 - 150 Amp, 230VAC: 5 - 210 Amp
MIG Welding Voltage Range	14 - 30 Volt
Wirefeed Speed Range	67 - 650 IPM (1.7 - 17.8 m/min)
Maximum Plate Thickness	3/8" (12.7 mm)
Wire Diameter Range	
Mild Steel:	.023" - .035" (0.6 - 0.9 mm)
Stainless Steel:	.023" - .035" (0.6 - 0.9 mm)
Aluminum:	.030" - 3/64" (0.8 - 1.2 mm)
Flux cored:	.030" - .045" (0.8 - 1.2 mm)
Warranty Period	3 Years*
Approvals	IEC 60974-1 (CE), ETL
Protection Class	IP23S
DIMENSIONS AND WEIGHT	
Dimensions H x W x D	H 17.32" x W 10.23" x D 23.62" (440 mm x 260 mm x 600 mm)
Weight	57.3 lbs (26 kg)

PRIMARY POWER	
Primary Voltage	115VAC, 208/230VAC
Supply Voltage Range	103 - 126VAC, 208 - 265VAC
Number of Phases	Single Phase
Supply Frequency	50/60Hz
Supply Plug	NEMA 6-50P
Rated kVA	115VAC - 4.5 kVA, 230VAC - 7 kVA
Lead Cord Length	9 ft (2.75 m)
Maximum Input Current	115VAC - 36.7 Amp, 230VAC - 30 Amps
REPLACEMENT ITEMS & CONSUMABLES	
Tweco® WeldSkill® 220 Amp MIG Gun, 12 ft	1023-1257
Nozzle 1/2" Bore	1210-1112
Diffuser	1510-1101
Liner	1420-1113
Contact Tips	Tweco 11-Series
Tweco WeldSkill 200 Amp Electrode Holder w/Lead, 13 ft, 50 mm Dinse	WS200E13
Tweco WeldSkill 200 Amp Ground Clamp w/Lead, 10 ft, 50 mm Dinse	WS200G10
Victor® CutSkill® Argon Regulator/Gauge	0781-4169
Gas Hose, 12.5 ft, Male 5/8-18UNF	W4013900

* Limited Warranty, refer to warranty schedule.











Comes Complete with:

- 1 Fabricator 211i Power Supply
- 2 Tweco WeldSkill 200 Amp Ground Clamp with 10 ft (3 m) Lead
- 3 12 ft Tweco WeldSkill 220 Amp MIG Gun
- 4 4 General Purpose Stick Electrodes (E6013)
- 5 Drive Rolls:
.023" / .030" (0.6 / 0.8 mm) V Groove
.023" / .035" (0.6 / 0.9 mm) V Groove (Installed)
.030" / .035" (0.8 / 0.9 mm) for flux cored wire
- 6 Bonus Contact Tips (1 each):
.023" (0.6 mm)
.030" (0.8 mm)
.035" (0.9 mm) Installed
.045" (1.2 mm)
- 7 Tweco WeldSkill 200 Amp Electrode Holder with 13 ft (4 m) Lead
- 8 Victor Argon Regulator/Gauge & 10 ft (3 m) Hose
- 9 230V-115V Adapter Plug & Cable
- 10 9 ft (2.75 m) Power Cord and NEMA 6-50P 230VAC Plug (*not shown*)
- 11 Operator's Manual & CD (*not shown*)

ORDERING INFORMATION

Equipment Option	Part No.	Description
Fabricator 211i Package	W1004201	Includes Fabricator 211i, Tweco® WeldSkill® 220 Amp MIG Gun, Victor Argon Regulator/Gauge & 10 ft (3 m) Hose, Tweco Electrode Holder & Ground Clamp, Drive Rolls & Contact Tips, Sample Electrodes, 230-115V Adapter Plug & Cable, Operator's Manual & CD
Fabricator 211i Package w/Cart	W1004202	Includes contents of W1004201 with Utility Cart W4014700

ACCESSORIES

TIG Torch & Accessories <i>(required for TIG welding)</i> 	W4014603	TIG Torch, 26V, 12.5 ft, 8 pin and accessory kit with 1/16", 3/32", 1/8" thoriated tungstens; 1/16", 3/32", 1/8" collets; 1/16", 3/32", 1/8" collet bodies; No. 5, 6, 7 Alumina nozzle; short back cap; long back cap
Spool Gun <i>(required for aluminum MIG welding)</i> 	1027-1390	Tweco Spool Gun 160A, 12 ft (3.6 m) Length, suits 4" (100 mm) spools
Basic Utility Cart 	W4014700	Utility Cart, accommodates maximum 7" diameter cylinder
Single Cylinder Cart 	W4015001	Single cylinder cart accommodates up to 9" diameter cylinder with accessory drawer and consumable compartment
Roll Cage 	W4015104	Protective Roll Cage for skidding or carrying (power supply not included)
Foot Control 	600285	Contacter On/Off and current control with 15 ft cable and 8-pin male plug
Power Adapter – 230V to 115V, 15A 	W4014000	Power adapter - 230V to 115V, 15A
Helmet 	4100-1004	TWECO WeldSkill Helmet (USA Only)

DRIVE ROLLS

Drive Roll .023" / .035" (0.6 / 0.9 mm)	W4014800	V groove for steel & stainless steel
Drive Roll .023" / .030" (0.6 / 0.8 mm)	7977036	V groove for steel & stainless steel wires (Installed)
Drive Roll .035" / .045" (0.9 / 1.2 mm)	7977660	V groove for steel & stainless steel wires
Drive Roll .030" / .035" (0.8 / 0.9 mm)	7977731	U grooved for aluminum wires
Drive Roll .040" / 3/64" (1.0 / 1.2 mm)	7977264	U grooved for aluminum wires
Drive Roll .030" / .035" (0.8 / 0.9 mm)	7977732	V knurled groove for flux cored wires
Drive Roll .045" (1.2 mm)	704277	V knurled groove for flux cored wire